

Date: Monday, 09/03/2009 1:46:20 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 46350	
<b>Estimate Number</b> : 12679	
<b>P.O. Number</b> :	<b>Part Number</b> : D35701 <b>GY</b>
<b>This Issue</b> : 09/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3570 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 32344	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/03/2009 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>TUD 09.03.09</u>	
<b>Comment</b> : Est Rev:A New Issue 07-01-30 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S125	6061-T6 .125 Sheet
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**Comment:** Qty.: 0.0746 sf(s)/Unit Total : 0.5964 sf(s)

6061-T6 .125 Sheet

Batch: 189-3-13

189-3-13

\*\*\*Grain must be Along 4.63\*\*\*\*\*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: CProg Rev: C

189-3-13

2-Deburr if necessary

189-3-13

(28)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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189-3-13

(28)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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189-3-13

(28)

**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

FF 09/03/24

(26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-1 PAR #: N/A Fault Category: Prod/FABassy mkt & smpl NCR: (Yes) No DQA: D Date: 09/05/12  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/05/12

NCR: <u>46350</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/24	5.0	2 0.328 Holes are off Centre	<u>[Signature]</u> 09/03/24	Destroy not replaced	09/03/24 FF	<u>S</u> 09/05/12	<u>[Signature]</u> 09/05/12	<u>[Signature]</u> 09/03-24
					<u>M-L</u> 09/04/08			
9/4/00								

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:46:20 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46350

Part Number: D35701

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

7 m.f 09/04/08 (264) (Pb) 7

6.0

QC5

INSPECT WORK TO CURRENT STEP



(23)

Comment: INSPECT WORK TO CURRENT STEP

809/05/07

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(23)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/05/07

8.0

POWDER COATING

POWDER COATING



m109091

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(23)

START TIME:

8:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

FL 09/05/11

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(23)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-11

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: 57245A

FL 09/05/11 (23)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion




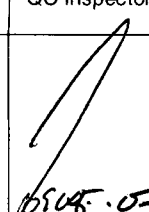


MF 09-05-11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-1 PAR #: N/A Fault Category: Prod/FAB assigned & small NCR: (Yes) No DQA: D Date: 09/05/12  
 Resolution: SCAP Disposition: Scrap QA: N/C Closed: D Date: 09/05/12

NCR: <u>46350</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/20	# S.3	Found Qty <del>10</del> parts with hole all centres by at least 0.0201. R.G. Human Error 2 parts holes are too low		Acceptable for usage. Scrap & destroy Qty 2	09/05/07 M.H.			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46350
<b>Description:</b> Bracket		<b>Part Number:</b> D3570-1
<b>Inspection Dwg:</b> D3570	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

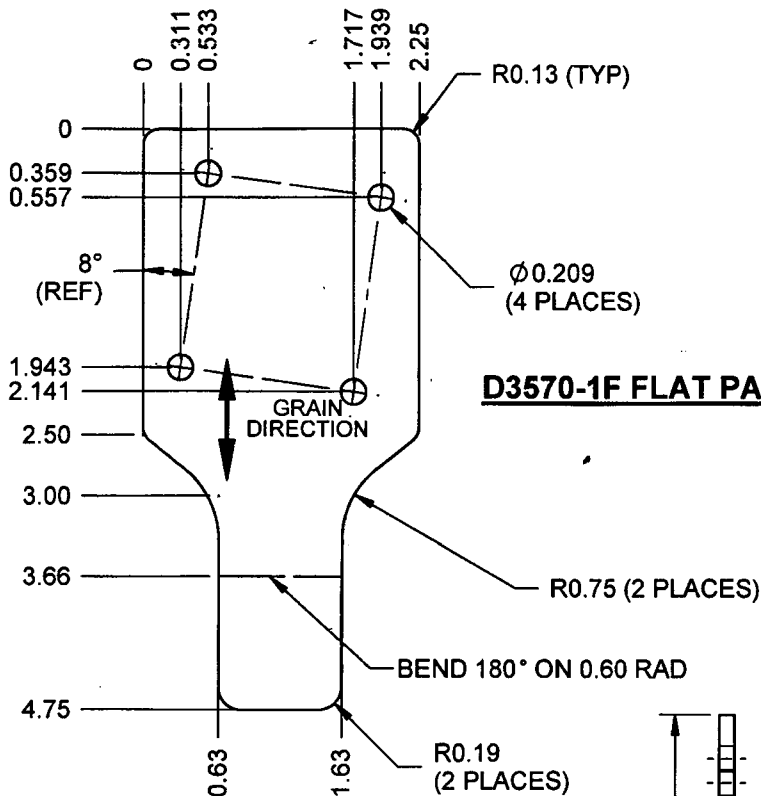
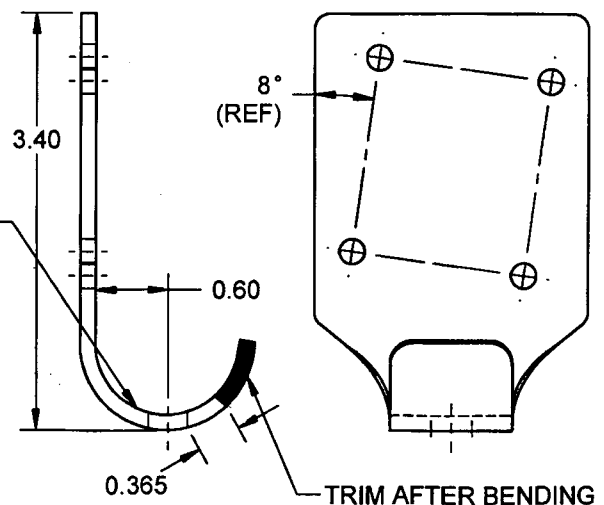
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	.211	X			
2.25	+/-0.030	2.255	✓			
4.75	+/-0.030	4.749	✓			
0.359	+/-0.010	.356	✓			
0.557	+/-0.010	.555	✓			
1.943	+/-0.010	1.945	✓			
2.141	+/-0.010	2.143	✓			
0.533	+/-0.010	.533	X			
1.939	+/-0.010	1.940	✓			
0.311	+/-0.010	.312	✓			
1.717	+/-0.010	1.717	✓			

<b>Measured by:</b> IB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> N/A
<b>Date:</b> 9-3-13	<b>Date:</b> 9-3-13	<b>Date:</b> N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.09.06	New Issue	KJ/JLM [Signature]	[Signature]

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET		SCALE 2:3
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	

**D3570-1F FLAT PATTERN****RELEASED**07.06.04 *H***D3570-1 BRACKET SHOWN**  
**(MAKE FROM D3570-1F)****D3570-2 BRACKET OPPOSITE**  
**(MAKE FROM D3570-1F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO APPROVAL

WORK ORDER  
46350

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